



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4895-045
Job Sheet 173449



Part No: D4895-045

Job Qty: 21 ea

Part Name: Fwd Outboard Beam Assembly



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/2/18

Job Tracking No:

Due Date: 3/9/18

Created By: Michelle Gagnon-Donovan

Type: Stock

Description:

Note: DWG REV B IPP REV:A 14.07.25 NEW ISSUE DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	3/8/18	3/8/18	0.00	0.00	Start Up Waterjet		18/03/26
100	Waterjet	1 pcs	3/8/18	3/8/18	0.00	0.84	Waterjet1		18/03/26
110	CNC Vertical Machining	1 pcs	3/8/18	3/8/18	1.13	3.33	HAAS1-5		18-05-05
120	QC	1 pcs	3/8/18	3/8/18	0.00	0.00	QC2 Machining-3		18-05-05
150	QC	1 pcs	3/8/18	3/8/18	0.00	0.00	QC8 Machining-3		18-05-05
160	HandFinish	1 pcs	3/8/18	3/8/18	0.00	0.24	HandFinish1		18-05-05
170	QC	1 pcs	3/8/18	3/8/18	0.00	0.00	QC7-4		18-05-05
171	Powdercoat	1 pcs	3/8/18	3/8/18	0.00	0.12	Powdercoat1		18-05-05
172	QC	1 pcs	3/8/18	3/8/18	0.00	0.00	QC3		18-05-05
180	Small Fab	1 pcs	3/9/18	3/9/18	0.00	0.19	Small Fab-8		18-05-05
190	QC	1 pcs	3/9/18	3/9/18	0.00	0.00	QC5		18-05-05
200	Packaging	1 pcs	3/9/18	3/9/18	0.00	0.00	Packaging3-2		18-05-05
210	QC21-SA	1 Ea	3/9/18	3/9/18	0.00	0.00	QC21		18-05-05

M139760

START: 9:35

OUT: 3:20

FINISH: 10:05

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B1.000X12.000	6061-T6 Bar 1.00 X 12.00	3.0100 ft (3.01 ea)	90-Start up Operation	
D4859-1	Bushing	4 Ea (4 ea)	180-Small Fab	50367358

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B1.000X12.000	3	16	0
180-Small Fab	D4859-1	4	16	0

Part Specifications

Specifications could not be found.

Plex 3/2/18 8:05 AM Dart.Gagnon.Michelle



Container No: S055032



Part: D4895 - 045

Job No: 173449

Serial No/Batch: S055032

Revision:

Inspector:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 813 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 03/26/18

DART AEROSPACE LTD		Work Order:	173449
Description: Fwd Outboard Beam		Part Number:	D4895-5
Inspection Dwg: D4895	Rev: B	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

	Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
CNC Milling	32.55	+/-0.030	32.550	✓		Tape	ref.
	R0.38	+/-0.030	R0.375	✓		R-G	ref.
	0.85	+/-0.030	0.847	✓		Vern	GA-B
	0.93	+/-0.030	0.928	✓		"	"
	8.32	+/-0.030	8.315	✓		H-G	31006
	Ø0.425	+0.000/-0.002	Ø0.424	✓		Mic/T-G	GA-03 / ref.
	0.750	+/-0.010	0.752	✓		Vern	GA-B
	0.200	+/-0.010	0.1985	✓		Mic	GA-03
	R0.43	+/-0.030	R0.430	✓		R-G	ref.
	3.00	+/-0.030	2.998	✓		Vern	GA-B
	3.50	+/-0.030	3.499	✓		"	"
	0.15	+/-0.030	0.150	✓		"	"
	0.250	+/-0.010	0.250	✓		Mic	GA-03
	5.75	+/-0.030	5.748	✓		Vern	GA-B
	1.34	+/-0.030	1.344	✓		H-G	31006
	1.00	+/-0.030	1.005	✓		Vern	GA-B
	R0.13	+/-0.030	R0.125	✓		R-G	ref.
	0.150	+/-0.010	0.159	✓		Mic	118-120
	1.15	+/-0.030	1.150	✓		Vern	GA-B
	3.00	+/-0.030	2.997	✓		"	"
	Ø0.377	+0.006/-0.001	Ø0.378	✓		"	"
	3.50	+/-0.030	3.498	✓		"	"
	1.75	+/-0.030	1.749	✓		"	"
	3.600	+/-0.005	3.600	✓		"	"
	1.800	+/-0.005	1.800	✓		"	"
	0.80	+/-0.030	0.798	✓		"	"
	0.60	+/-0.030	0.597	✓		"	"
	2.300	+/-0.005	2.300	✓		"	"
	Ø1.00	+/-0.030	Ø0.999	✓		"	"
Manual Mill	0.25	+/-0.030	0.253	✓		D-G	GA-03
	5.50	+/-0.030	5.501	✓		Vern	GA-B
	12.000	+/-0.005	12.000	✓		Vern	CNC-02
	1.55	+/-0.030	1.551	✓		"	"
	Ø0.465 X 90°	+/-0.010 x 0.5°	Ø0.470 x 90°	✓		"	"
	R0.25	+/-0.030	R0.250	✓		R-G	ref.
	0.500	+/-0.010	0.499	✓		Mic	GA-03

Measured by: D.A.	Audited by: mmr L	Preliminary Approval:
Date: 18-05-05	Date: 18/05/08	Date:
Rev	Date	Change
A	14.08.05	New Issue
Revised By		Approved
KJ		[Signature]